

Date: Tuesday, 29/07/2008 4:55:32 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 02.750 SUPPORT
 Job Number : 40781
 Estimate Number : 10829
 P.O. Number :
 This Issue : 29/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 39527
 Part Number : D28931
 Drawing Number : D2893 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 08/08/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUL 08.7.29
 Comment : Est: C 02.11.26 Reformat; Added P/O KJ
 est D 06.04.19 removed alodine EC
 Est Rev:E Added priming as per Rev B 07-04-30 JLM
 est F 08.03.19 Re-format EC verified by: DD
 Est Rev:G 08-05-15 add QC14 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DSK078

D2893-1 TURNING DETAIL



5
~~13x 38131~~ 25/08/08/10



Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2893-1 TURNING DETAIL

Batch: B 39858 10x

N.A 08/08/09

2.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS 1

Machine as per Folio FA081

Tumble & Deburr

N.A 08/08/12 / 25 08/08/09 (20)

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT ALL DIM TO DIM SHEET

N.A 08/08/12 / 25 08/08/09 (20)

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

20 08/08/13 20

5.0 POWDER COATING

POWDER COATING



M 108523



20X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3.

Mask Inside Bore for Priming

START TIME:

7:40

M-2 08/08/14

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 29/07/2008 4:55:32 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 40781

Part Number: D28931

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 400

FINISH TIME: 8-10

INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

QC3



Comment: INSPECT POWDER COAT

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1.

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 40781 |
| Description: Ø2.750 Support | | Part Number: D2893-1 |
| Inspection Dwg: D2893 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 2.997 | 3.000 | 3.000 | 3.000 | 3.000 |
| AB | 0.440 | 0.460 | | .440 | .445 | .447 | .447 | .447 |
| AC | 0.125 | 0.160 | | .153 | .149 | .149 | .149 | .147 |
| AD | 0.040 | 0.060 | | .049 | .054 | .054 | .054 | .055 |
| AE | 0.188 | 0.193 | | .188 | .183 | .188 | .188 | .188 |
| AF | 0.125 | 0.160 | | .141 | .150 | .143 | .143 | .150 |
| AG | 0.140 | 0.160 | | .154 | .160 | .143 | .143 | .150 |
| AH | 1.360 | 1.400 | | 1.365 | 1.365 | 1.360 | 1.370 | 1.370 |
| AI | 0.040 | 0.060 | | .049 | .050 | .050 | .050 | .050 |
| AJ | 1.190 | 1.230 | | 1.204 | 1.214 | 1.205 | 1.212 | 1.205 |
| AK | 0.010 | 0.020 | | .015 | .015 | .015 | .015 | .015 |
| AL | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AM | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AN | 2.518 | 2.538 | | 2.536 | 2.528 | 2.522 | 2.518 | 2.518 |
| AO | 84.39 | 90.39 | | 87.39 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | .261 | .265 | .265 | .265 | .255 |
| AQ | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

Measured by: LS
 Date: 08/08/09

Audited by: mx
 Date: 08/08/13

Prototype Approval: _____
 Date: _____

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | |

| | | |
|------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 40281 |
| Description: Ø2.750 Support | | Part Number: D2893-1 |
| Inspection Dwg: D2893 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 61 | 72 | 83 | 92 | 105 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 3.000 | 3.000 | 3.000 | 2.997 | 2.997 |
| AB | 0.440 | 0.460 | | .447 | .450 | .450 | .447 | .450 |
| AC | 0.125 | 0.160 | | .150 | .150 | .150 | .150 | .150 |
| AD | 0.040 | 0.060 | | .052 | .051 | .050 | .050 | .050 |
| AE | 0.188 | 0.193 | | .188 | .188 | .188 | .188 | .188 |
| AF | 0.125 | 0.160 | | .150 | .150 | .150 | .150 | .150 |
| AG | 0.140 | 0.160 | | .147 | .147 | .147 | .147 | .147 |
| AH | 1.360 | 1.400 | | 1.365 | 1.365 | 1.370 | 1.370 | 1.370 |
| AI | 0.040 | 0.060 | | .050 | .050 | .050 | .050 | .050 |
| AJ | 1.190 | 1.230 | | 1.205 | 1.205 | 1.205 | 1.205 | 1.210 |
| AK | 0.010 | 0.020 | | .015 | .015 | .015 | .015 | .015 |
| AL | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AM | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AN | 2.518 | 2.538 | | 2.520 | 2.520 | 2.520 | 2.520 | 2.520 |
| AO | 84.39 | 90.39 | | 87.39 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | .266 | .266 | .266 | .266 | .266 |
| AQ | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

Measured by: S.J. Date: 08/08/11

Audited by: [Signature] Date: 08/08/13

Prototype Approval: Date:

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|-------------|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | [Signature] |

| | | |
|------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 40781 |
| Description: Ø2.750 Support | | Part Number: D2893-1 |
| Inspection Dwg: D2893 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1/ | 1 2 | 1 3 | 1 4 | 1 5 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 3.000 | 3.003 | 3.000 | 3.006 | 2.998 |
| AB | 0.440 | 0.460 | | .450 | .450 | .447 | .447 | .441 |
| AC | 0.125 | 0.160 | | .150 | .150 | .150 | .160 | .142 |
| AD | 0.040 | 0.060 | | .050 | .056 | .050 | .050 | .049 |
| AE | 0.188 | 0.193 | | .188 | .188 | .188 | .188 | .0190 |
| AF | 0.125 | 0.160 | | .150 | .150 | .150 | .147 | .145 |
| AG | 0.140 | 0.160 | | .147 | .147 | .147 | .150 | .152 |
| AH | 1.360 | 1.400 | | 1.365 | 1.365 | 1.360 | 1.365 | 1.351 |
| AI | 0.040 | 0.060 | | .051 | .050 | .050 | .050 | .049 |
| AJ | 1.190 | 1.230 | | 1.206 | 1.206 | 1.210 | 1.213 | 1.211 |
| AK | 0.010 | 0.020 | | .015 | .015 | .015 | .015 | .017 |
| AL | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AM | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AN | 2.518 | 2.538 | | 2.520 | 2.520 | 2.522 | 2.533 | 2.522 |
| AO | 84.39 | 90.39 | | 87.39 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | .266 | .266 | .266 | .262 | 0.263 |
| AQ | 0.053 | 0.073 | | .063 | .067 | .063 | .063 | 0.063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

Measured by: *SD* **Date:** 08/08/11

Audited by: *Am* **Date:** 08/08/13

Prototype Approval: **Date:**

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|-----------|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | <i>Am</i> |

40781

| | | |
|------------------------------|--|-------------------------------|
| DART AEROSPACE LTD | | Work Order: 387167 |
| Description: Ø2.750 Support | | Part Number: D2893-1 |
| Inspection Dwg: D2893 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 16 | 17 | 18 | 19 | 20 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 2.998 | 2.995 | 2.995 | 2.998 | 2.998 |
| AB | 0.440 | 0.460 | | .441 | .440 | .440 | .440 | .440 |
| AC | 0.125 | 0.160 | | .154 | .144 | .159 | .141 | .147 |
| AD | 0.040 | 0.060 | | .049 | .050 | .049 | .050 | .050 |
| AE | 0.188 | 0.193 | | 0.190 | 0.190 | 0.190 | 0.190 | 0.190 |
| AF | 0.125 | 0.160 | | .142 | .145 | .140 | .142 | .141 |
| AG | 0.140 | 0.160 | | .149 | .150 | .149 | .145 | .145 |
| AH | 1.360 | 1.400 | | 1.373 | 1.369 | 1.395 | 1.375 | 1.374 |
| AI | 0.040 | 0.060 | | .049 | .050 | .050 | .050 | .050 |
| AJ | 1.190 | 1.230 | | 1.214 | 1.210 | 1.214 | 1.216 | 1.216 |
| AK | 0.010 | 0.020 | | .017 | .017 | .017 | .017 | .017 |
| AL | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AM | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AN | 2.518 | 2.538 | | 2.525 | 2.520 | 2.523 | 2.524 | 2.524 |
| AO | 84.39 | 90.39 | | 87.37 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | .264 | .262 | .262 | .262 | .262 |
| AQ | 0.053 | 0.073 | | 0.063 | .063 | .063 | .063 | .063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

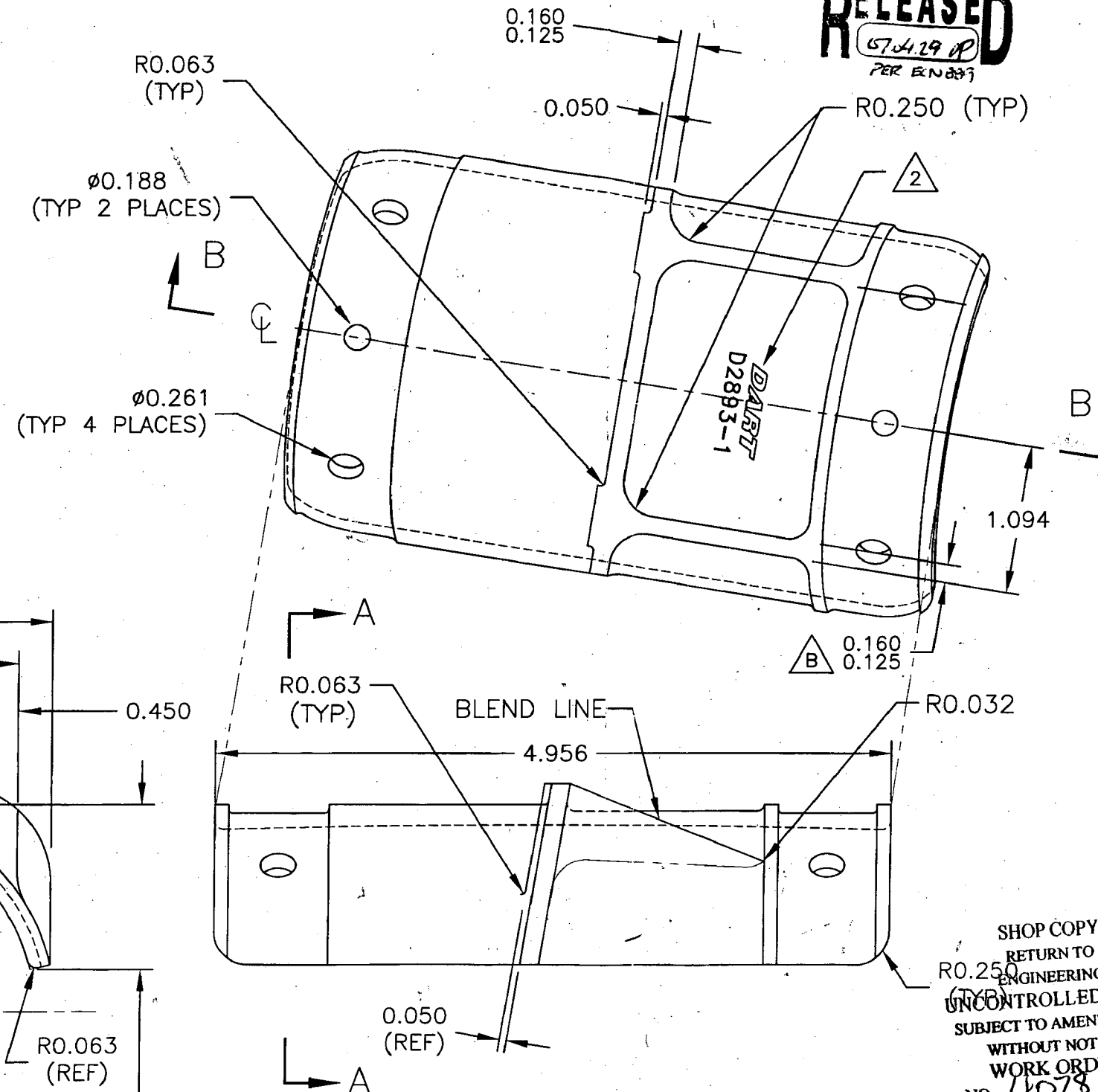
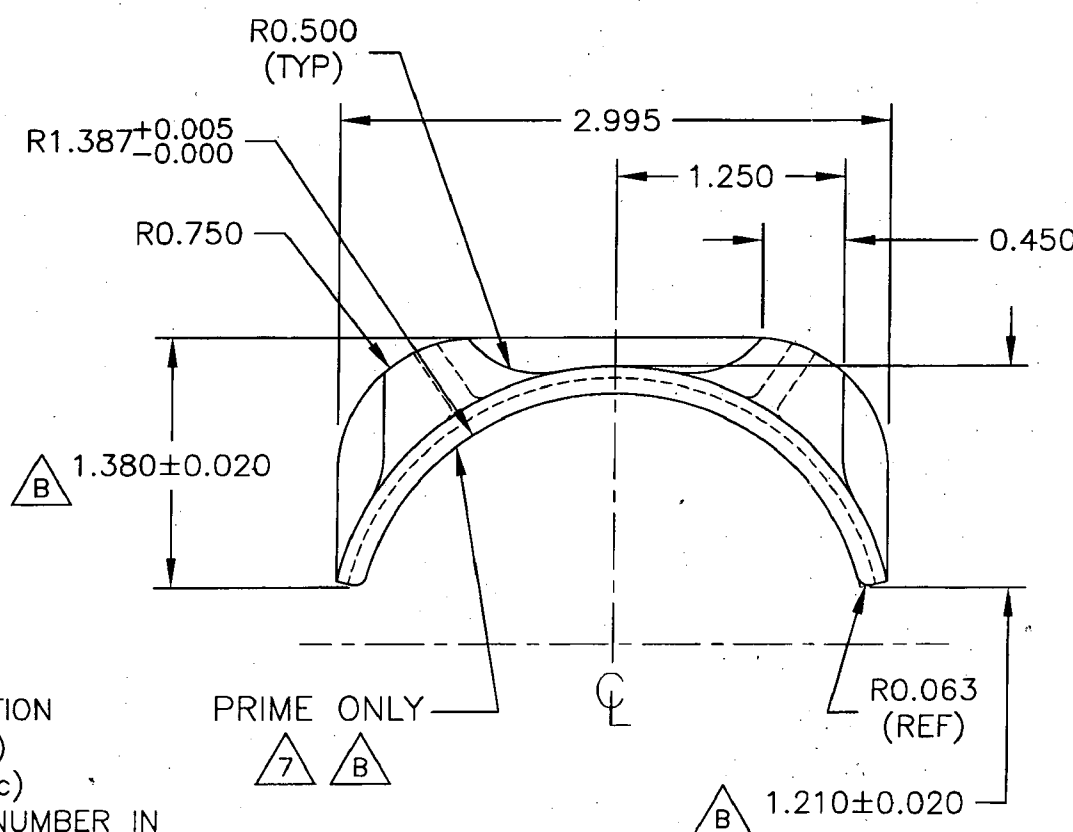
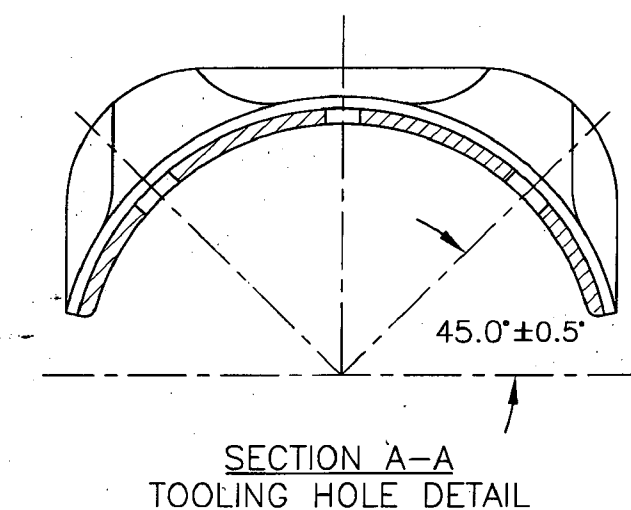
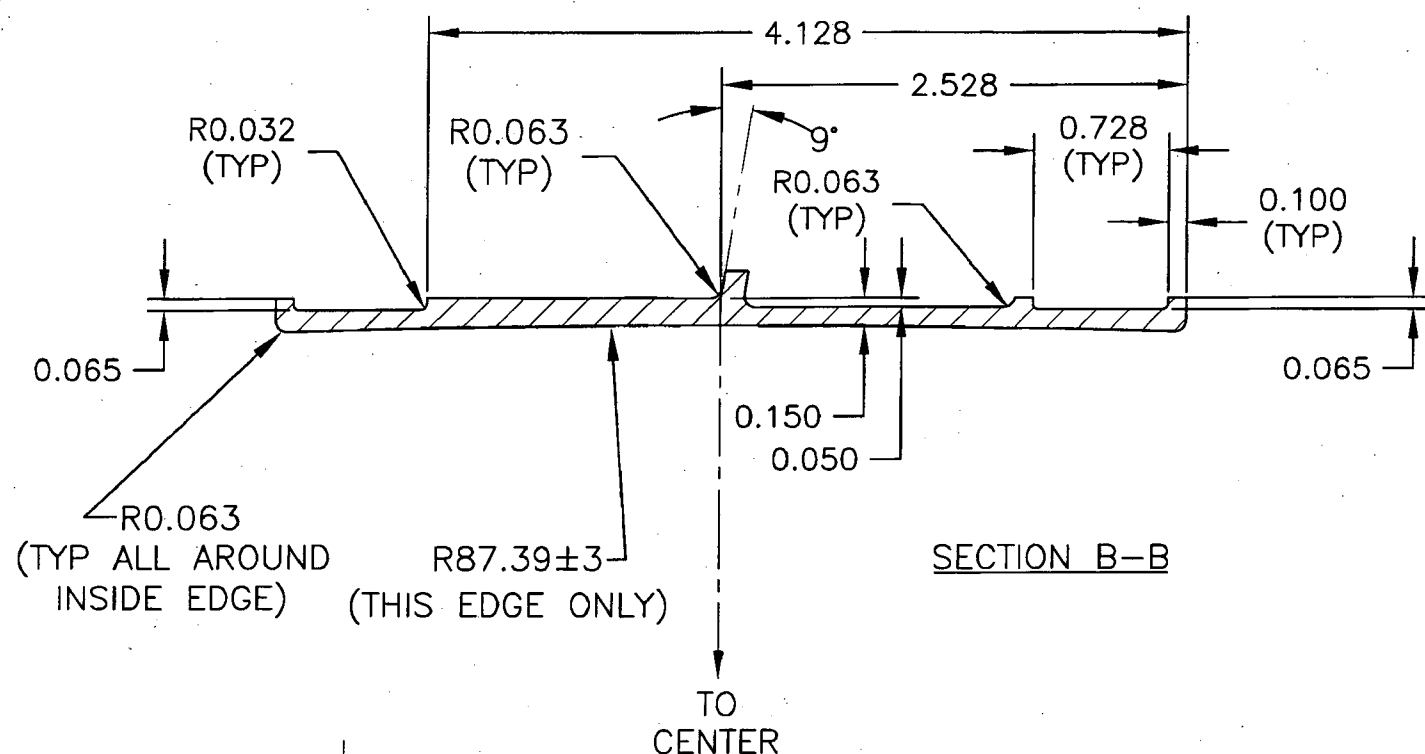
| | |
|-------------------|----------------|
| Measured by: M. A | Date: 08/08/12 |
|-------------------|----------------|

| | |
|--------------------------------|----------------|
| Audited by: <i>[Signature]</i> | Date: 08/08/13 |
|--------------------------------|----------------|

| | |
|---------------------|-------|
| Prototype Approval: | Date: |
|---------------------|-------|

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|--------------------|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | <i>[Signature]</i> |

RELEASED
 674129 P
 PER EN 883



D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
 HEAT TREAT TO H900 CONDITION
 (900°F FOR 1 HR, AIR COOL)
 MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
 THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
 PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 40781

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 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.

| | | |
|---------|----------|-----------------------------------|
| B | 07.03.16 | UPDATE DIMS AS MFG., PRIME INSIDE |
| A | 01.01.10 | NEW ISSUE |
| DESIGN | GP | DRAWN BY PH |
| CHECKED | TH | APPROVED TH |
| DATE | 07.03.16 | TITLE |
| | | D2893 |
| | | 02.750 SUPPORT |

DART DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

REV. B
 SHEET 1 OF 1

SCALE
 1:1

